

Work Order ID 73662

Monday, September 12, 2011 10:12:52 AM



Page 1

Item ID: D3340-13

Accept



Setup Start



Revision ID:

Item Name: Aft Skidtube Protector

Stop



Start Date: 9/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/14/2011 Req'd Qty: 4.00



Customer:

ASAP

Reference:

Approvals:

Process Plan:

MF

Date: *11-09-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3340

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3340 ☒ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary

1010.040

B11-9-13



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/13



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Page 2

Item ID: D3340-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Skidtube Protector

Start Date: 9/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Debur if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261

SB 11/09/13

5

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/09/13

4

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

9:10

9:40

3200F






5X Ø M-L 11/09/14



M117338




Work Order ID 73662

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Item ID:	D3340-13	Accept		Setup	Start	
Revision ID:						
Item Name:	Aft Skidtube Protector				Stop	
Start Date:	9/12/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	9/14/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				5	6		11/09/11
170 	Identify as per dwg & Stock Location: <i>Ysf</i>	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Run 9/14 (5)

11/9/14

mf 11-09-14

Picklist Print

Monday, September 12, 2011 10:12:48 AM

Page 1

Work Order ID: 73662

Parent Item: D3340-13

Parent Item Name: Aft Skidtube Protector





Start Date: 9/12/2011

Required Date: 9/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC
IPP Rev:B Now on Waterjet 06-10-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA  1010/1025 SHEET		Purchased	No			110	sf	150.5000	1.258	5.296842	6.3		
											1811-9-13		

Location

Loc Qty

Loc Code

MAT019

150.5

111410

64

116791

86.5

111410

DART AEROSPACE LTD		Work Order: 73662
Description: Aft Skidtube Protector		Part Number: D3340-13
Inspection Dwg: D3340	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.254	✓		V BUL	
0.300	+/-0.010	.304	✓		V	
0.50	+/-0.030	.499	✓		V	
0.250	+/-0.010	.246	✓		V	
2.315	+/-0.010	2.318	✓		V	
2.815	+/-0.010	2.812	✓		V	
1.625	+/-0.010	1.623	✓		V	
23.125	+/-0.010	23.125	✓		T BUL	
26.625	+/-0.010	26.624	✓		T	
52.315	+/-0.010	52.315	✓		T	
55.815	+/-0.010	55.815	✓		T	
58.190	+/-0.010	58.190	✓		T	
61.000	+/-0.010	61.000	✓		T	
63.565	+/-0.010	63.565	✓		T	
0.040	+/-0.010	.038	✓		T	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-9-13	Date: 11/09/13	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

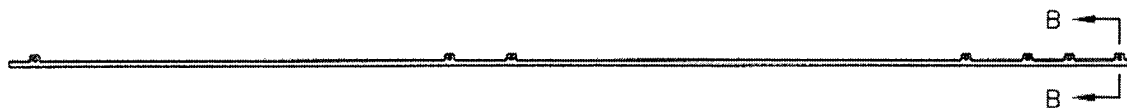
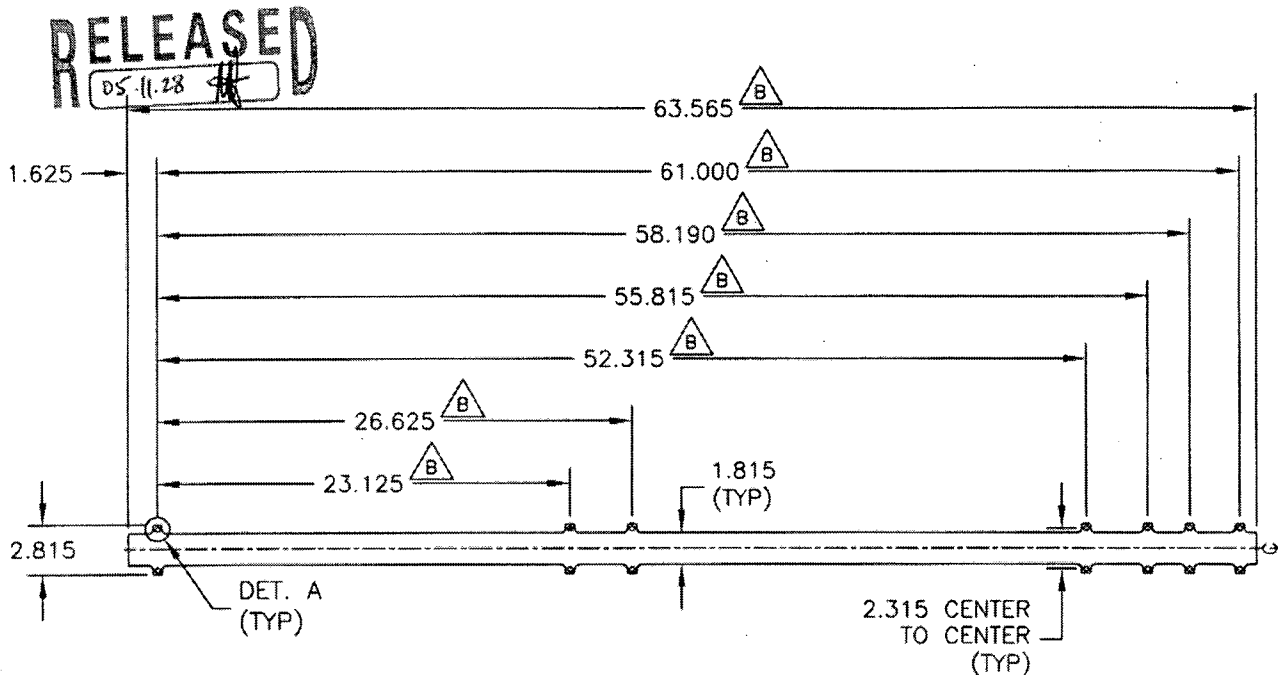
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3340	REV. B SHEET 6 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-13 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

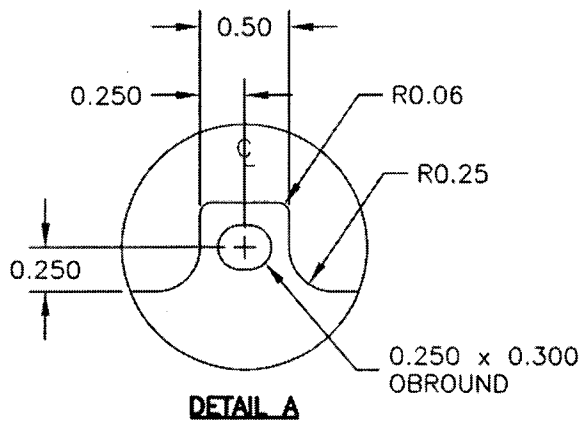
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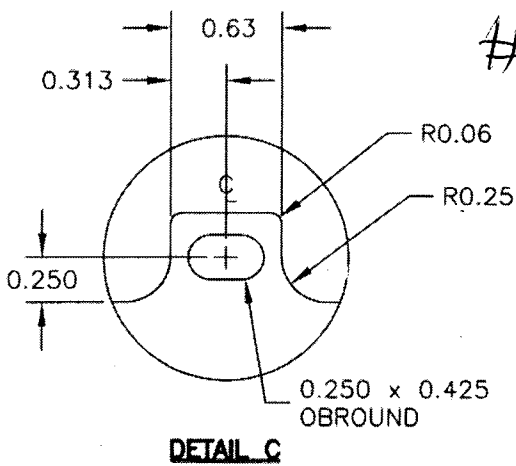
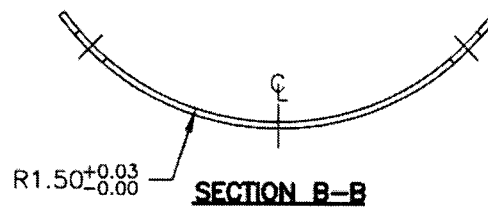
NOTE: Date & initial all entries



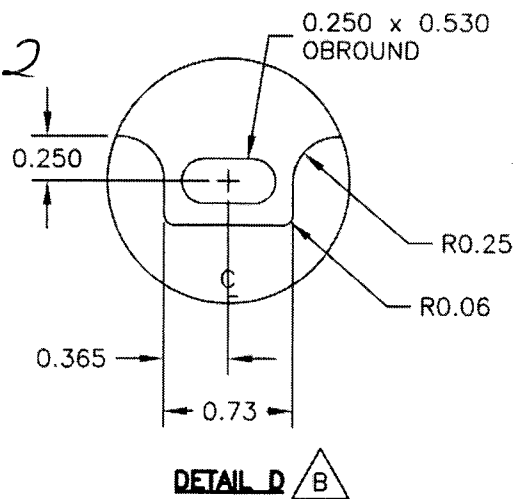
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3340	REV. B SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



RELEASED
15-11-28 #



73662



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NOTE: Date & initial all entries